

Date: Monday, 11/08/2008 2:45:48 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WINDOW FRAME		
Job Number	: 41133			Part Number	: D2956	
Estimate Number	: 10624			Drawing Number	: D2956 REV C	
P.O. Number	:			Project Number	: N/A	
This Issue	: 11/08/2008		S.O. No. :	Drawing Revision	: C	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	SMALL /MED FAB	Due Date	29/08/2008
Previous Run	: 36857				Qty:	10
Written By	:			Um:	Each	
Checked & Approved By	: JUO 08.8.11					
Comment	: Est. A00.01.14 New issue EC					
	Est Rev:B Now on Waterjet 07-06-25 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S040	5052-H32 .040 Sheet	<i>HB 8-8-20</i>
		Comment: Qty.: 3.3907 sf(s)/Unit Total : 33.9066 sf(s) 5052-H32 .040 Sheet Material: 5052-H34 sheet 0.040" thick. <i>HB 8-8-20</i>	
		Batch <i>107813</i>	<i>CUT of MAT</i>
2.0	WATER JET	FLOW WATER JET	<i>HB 8-8-20</i>
		Comment: FLOW WATER JET 1-Cut as per Dwg D2956 Dwg Rev: <i>C</i>	<i>7</i>
		Prog Rev: <i>C</i>	
		2-Deburr if necessary	<i>HB 8-8-20</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	<i>HB 8-8-20</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	<i>S 08/08/20 (x7)</i>
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	<i>HB 08/08/21 (x7)</i>
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 2:45:48 PM
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Drawing Name: WINDOW FRAME

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



u/08523



(6)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:00

OVEN TEMPERATURE:

320°

FINISH TIME:

9:30

Fx 08/08/22

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

08/08/25

(7x)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



(7x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 209

8/8/25

(8)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.08.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41133
Description: Window Frame	Part Number:	D2956
Inspection Dwg: D2956	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

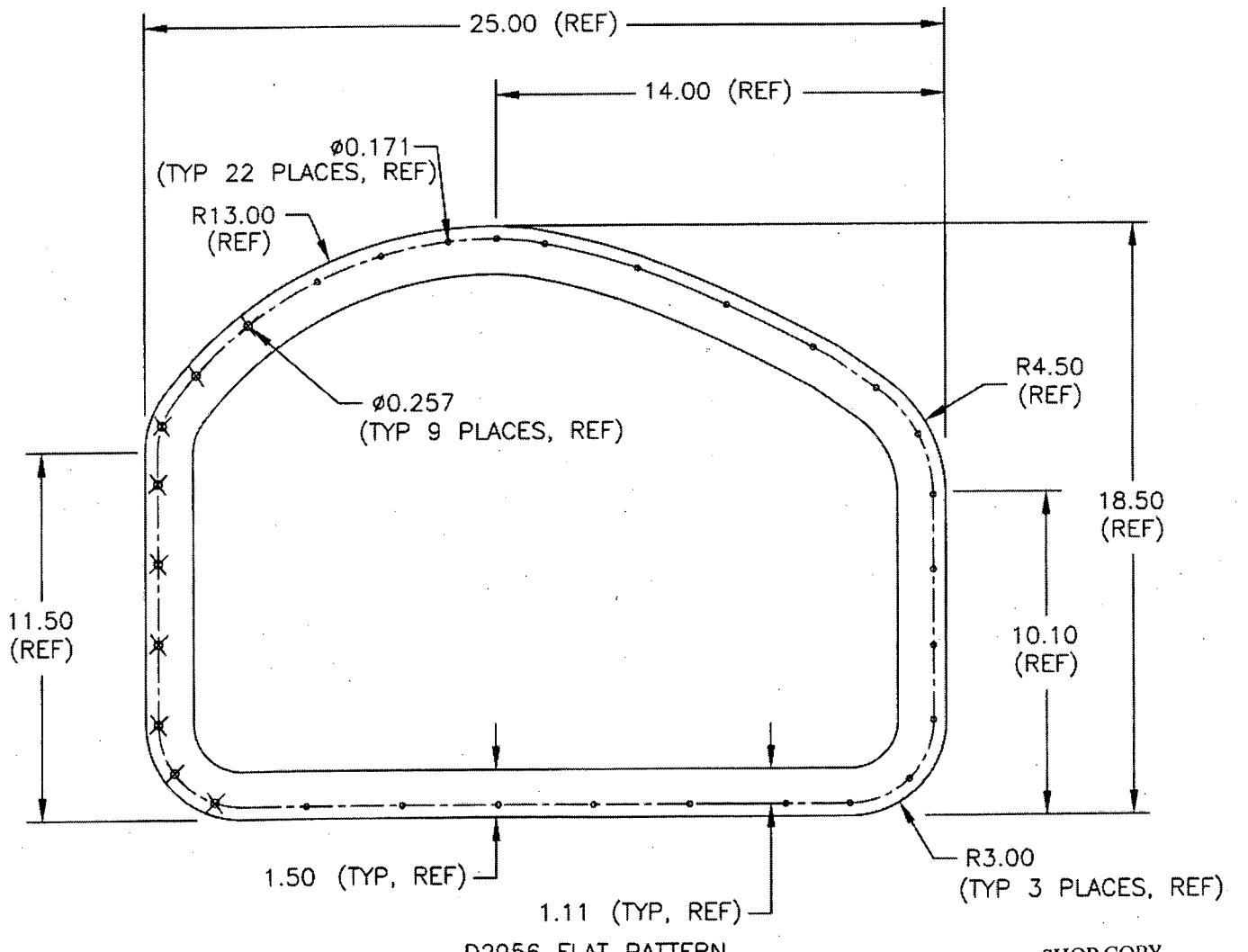
Measured by: <u>BB</u>	Audited by: <u> </u>	Prototype Approval: N/A
Date: <u>9-8-26</u>	Date: <u>01/09/00</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-025	KJ/RF	FF



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2956 REV. C SHEET 1 OF 1
DATE		TITLE SCALE
01.06.04		WINDOW FRAME 1:5
A	00.01.20	NEW ISSUE
B	00.02.23	Ø0.141 HOLES WERE Ø0.128 (NCR 407)
C	01.06.04	REMOVE Ø0.141 HOLES

RELEASED
01.06.05



D2956 FLAT PATTERN

MACHINE PER DRAWING FILE "D2956-C1.DWG"

CHECK HOLES PER TEMPLATE DT8437

BEND PER TEMPLATE DT8567

MATERIAL: 5052-H34 (QQ-A-250/8) SHEET 0.040 THICK

FINISH: POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 41133

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